

Stool.

Work Order ID 157040

157040

Page 1

Thursday, February 09, 2017 2:28:48 PM

Item ID: D407-836-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 2/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2017 Req'd Qty: 1.00

1

Customer:

Reference: 10-3-2017
24-3-2017

Approvals: Process Plan:

Date:

FEB 09 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

GA202-2

A

FEB 10 2017

DAS
6
9-89

100

Document Control

MAR 15 2017

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D407-836-017 CH001

DAS
27
9-89

DAS
21
9-89

17-03-16

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MAR 16 2017

DAS
6
9-89

MAR 15 2017

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

DAS
27
9-89

MAR 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Thursday, February 09, 2017 2:28:48 PM

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Page 2

Item ID: D407-836-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 2/10/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-836-017								
	Location: _____								
	PPP Rev: _____ <i>fs 122</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
27
9-89

MAR 1 6 2017

DAS
21
9-89

MAR 1 6 2017

DAS
21
9-89

MAR 1 6 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 1

Work Order ID: 157040

157040

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 2/10/2017

Required Date: 2/14/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1 *D4853-1* Top Bracket		Manufactured	No				Each	14.0000	**	1		MAR 15 2017	DAS 28 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST519			14						
					148141		14						
D4854-1 *D4854-1* Lower Bracket		Manufactured	No				Each	5.0000	**	1		MAR 15 2017	DAS 28 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st526			5						
					149686		1						
					156010		4						
D4855-1 *D4855-1* Antenna Bracket		Manufactured	No				Each	12.0000	**	1		MAR 15 2017	DAS 28 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st526			12						
					148948		4						
					155392		8						
D2732-030 *D2732-030* Rubber Cushion - 3"		Manufactured	No				Each	192.0000	**	2		MAR 15 2017	DAS 28 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FG			35						
					150011		35						
				ST410			157						
					154138		157						

157143

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 157040

157040

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 2/10/2017

Required Date: 2/14/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-16A Purchased No Each 211.0000

AN4-16A

Bolt

**

Location Loc Qty Loc Code

FG 5

121541 5

over003 100

M136740 100

ST343 106

M136648 106

AN4-11A Purchased No Each 95.0000

AN4-11A

BOLT

**

Location Loc Qty Loc Code

FG 20

120731 20

ST344 75

M136263 75

NAS1149D0432J Purchased No Each 498.0000

NAS1149D0432.J

WASHER

**

Location Loc Qty Loc Code

GA 24

m131026 24

ST264 474

m134676 474

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Picklist Print

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Thursday, February 09, 2017 2:28:53 PM

Work Order ID: 157040

157040

Parent Item: D407-836-017

D407-836-017

Parent Item Name: Crosstube Antenna Mount 407 Aft (P162-407A)

Start Date: 2/10/2017

Required Date: 2/14/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

1,648.000

MS21042L4

Nut

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

187

m135058

187

OVER007

500

m136450

500

ST303

943

m136648

943

136838

DAS
27
9-86

DAS
28
9-86

MAR 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT